


120	QC5- Inspect part completeness to step on W/O	0.00
		
QC	Memo	0.00
Quality Control		

Pl 09 11 11

PD 09.11.1

9 _____ 05.11.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53226

October 27, 2009 1:05:12 PM



Page 2

Item ID: D3943-053

Accept



Setup Start



Revision ID: B

Item Name: Chain Assembly

Stop



Start Date: 10/27/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 11/2/2009 Req'd Qty: 9.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



SprayPaint

Spray Painting per QSI005 4.2

0.00

Memo

0.00

Spray Painting

1- MASK CHAIN FROM THIS POINT ON PRIOR TO PAINTING AS PER DWG

2- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH: M113541

Powder coat Hybrid Yellow H3112 Y12 (Ref PAR10-001 10-01-07)
Start: 2:00pm Temp: 3:20°F Stop: 2:30pm

140



QC

Quality Control

QC14- Inspect Spray Paint

QC3

Memo

0.00

0.00

Identify as per dwg & Stock Location: W/O

0.00

Memo

0.00

150



Packaging

Packaging

52944

EL 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53226

October 27, 2009 1:05:12 PM



Page 3

Item ID: D3943-053

Accept



Setup Start



Revision ID: B

Item Name: Chain Assembly

Stop



Start Date: 10/27/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 11/2/2009 Req'd Qty: 9.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/13

MF 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 27, 2009 1:05:12 PM

Page 1

Work Order ID: 53226



Parent Item: D3943-053RevA



Parent Item Name: Chain Assembly


Start Date: 10/27/2009

Required Date: 11/2/2009

Comments:

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3954-5RevA  Chain Lug		Manufactured	No			100	Each	11.0000	9.0000			

Cpl 09.11.11

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST139C

11

52098

6

52982

5

100

Each

35.0000

9.0000



④
⑤

✓

D3954-9RevA

Manufactured

No



GWT Chain Pin

Cpl 09.11.11

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

35

52100

4

52193

1

52991

30

③

✓

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS

RELEASED
2009-10-19

B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.13
REV.	DESCRIPTION		BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	REV. B		
CHECKED		DRAWING NO.	SHEET 1 OF 5	
MFG. APPR.		D3943		
APPROVED		TITLE	SCALE	
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS	
DATE	09.10.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND IS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

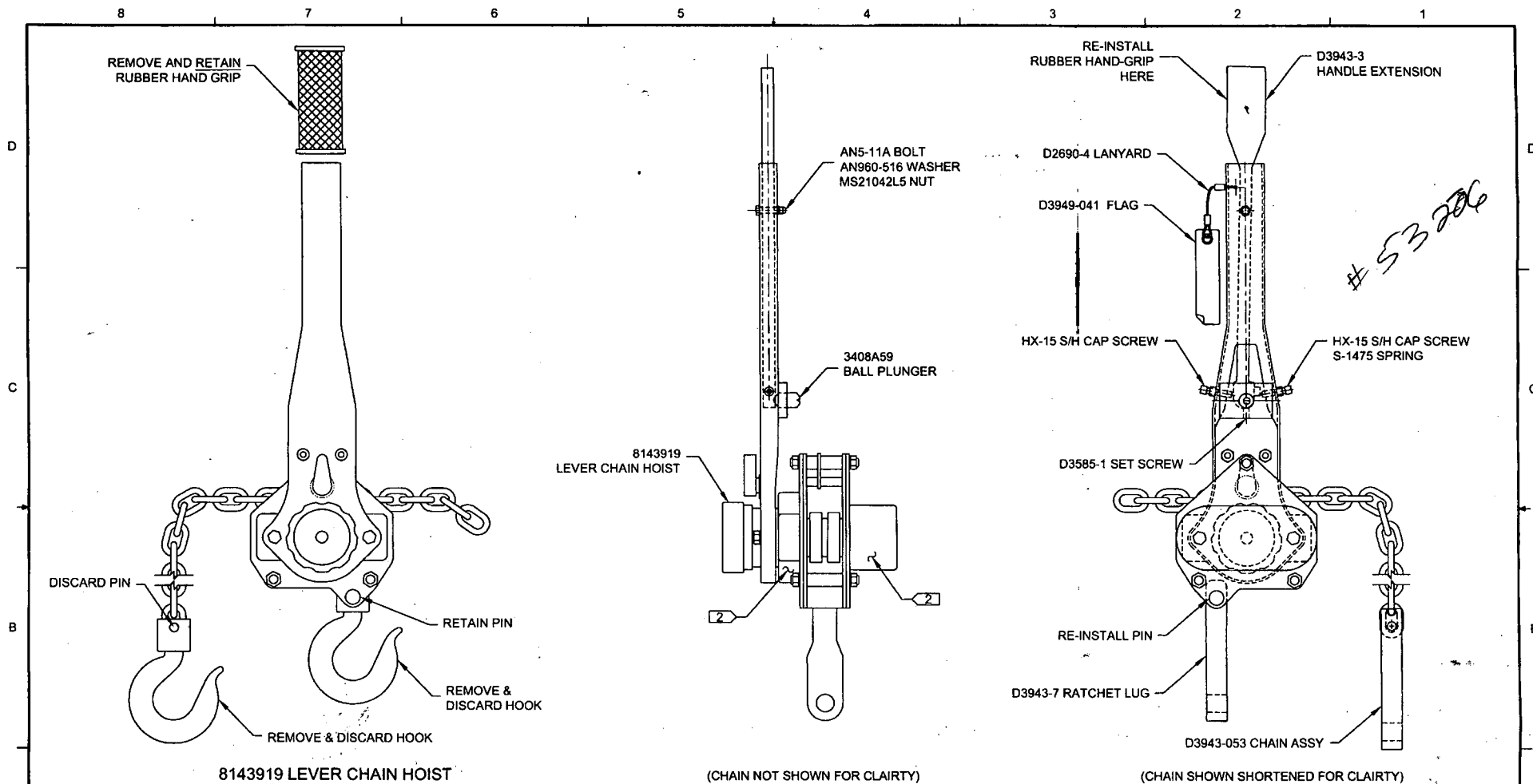
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3943-041 GROUND HANDLING CRANK ASSEMBLY

NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: DISASSEMBLE LEVER CHAIN HOIST (ITEM 39) AND SPRAY PAINT YELLOW WITH BERTRAND GG4031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER

Powder Coat Hybrid Yellow
MS112 Y12 Ref PAR10-001

10-01-07
MPO-01-07

RELEASED
2009-10-19

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO. D3943	REV. B
CHECKED			SHEET 2 OF 5
MFG. APPR.		TITLE GROSS WEIGHT TOW CRANK ASSY	SCALE NTS
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DE APPR.		DATE 09.10.15	

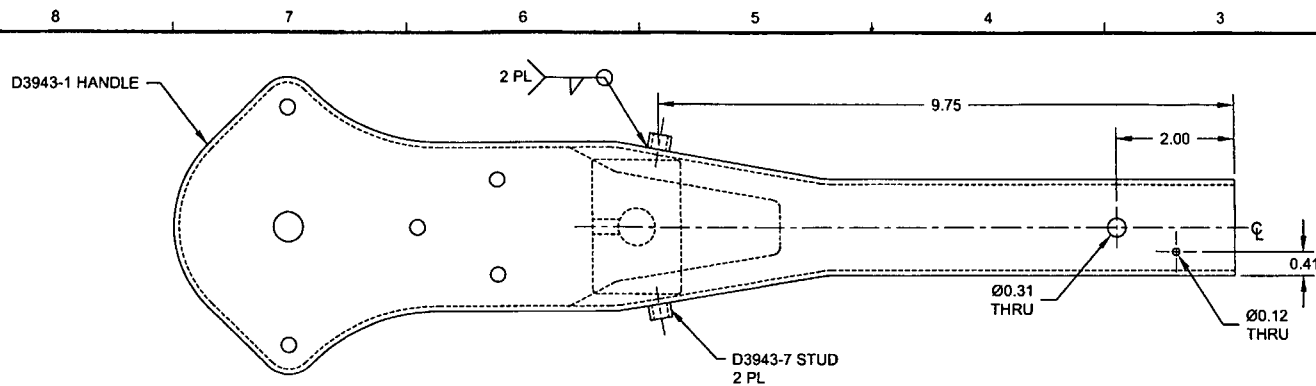
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

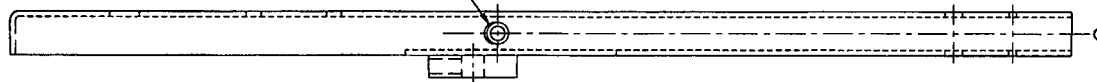
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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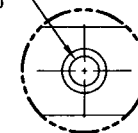


#53226

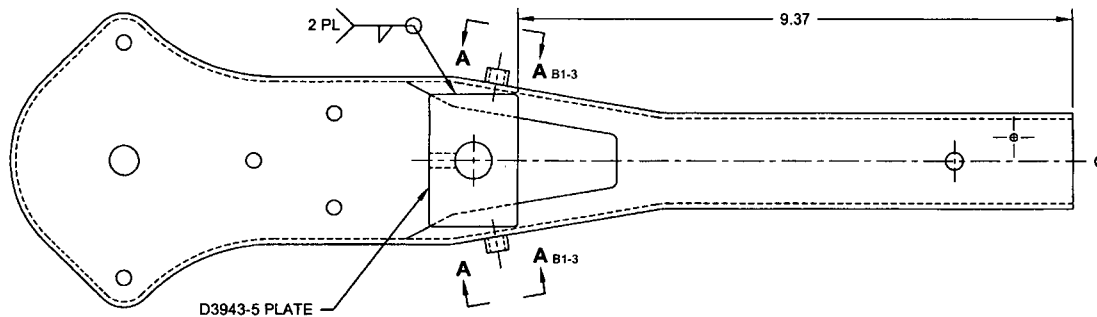
THREAD $\frac{1}{4}$ -20 UNC-2B
2 PL



THREAD $\frac{1}{4}$ -20 UNC-2B
THRU






VIEW A-A A5-3
(SCALE 2X) B5-3



D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2 \triangle
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	AJS	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D3943-9 CHAIN

D3954-5 CHAIN LUG

C

C


B




B

D3943-053 CHAIN ASSEMBLY

RELEASED
2009-10-18
MP

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2 
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
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8 7 6 5 4 3 2 1

A

A

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